Date: Wednesday, 5/16/2007 7:57:16 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STOP
Job Number	: 32353		
Estimate Number	: 10731		
P.O. Number	: N/A	Part Number	: D23243
This Issue	: 5/16/2007 S.O. No. : N/A	Drawing Number	: D2324 REV. C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: 32278A	Material	: N/A
		Due Date	: 5/30/2007 Qty: 30 Um: Each

Written By   :

Checked & Approved By :   KJ 07.05.16

Comment   : Est: E 03.02.28   Reformat; Incorporated D2324-3 &
D2324-5   KJ/RF

Additional Product

Job Number:

||||||||||||||||||

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X00750	6061-T6 Bar .75" x .75"

Comment: Qty.:   0.5565 f(s)/Unit   Total :   16.6950 f(s)
6061-T6 Bar 0.75" x 0.75"
Material: 6061-T6/6511 (QQ-A-200/8) or (QQ-A-225/8) or 5052-H34 (QQ-A-225/7) or (QQ-A-250/8)
(M6061T6B0.750x00.750)   Batch: M10015?

2.0	BAND SAW	BAND SAW

Comment: BAND SAW
Cut blanks: (0.75" x 0.75") x 5.75" Long Bar   JA 07.06.12

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1

Comment: HAAS CNC VERTICAL MACHINING #1
1- Machine as per Folio D2324-3 and Dwg D2324
2- Deburr and Tumble to remove sharp edges
Identify as D2324-3   JA 07.06.12   (30)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE   JA 07.06.12   (30)

5.0	QC8	SECOND CHECK

Comment: SECOND CHECK   MS 07/06/12   30

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: _____ Date: 07/06/14

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STOP

Job Number: 32353

Part Number: D23243

Job Number:

Seq. #:	Machine Or Operation:	Description :
6.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1

09-06-13 / 30

| 7.0 | QC3 | INSPECT POWDER COAT/CHEMICAL CONVERSION |

Comment: INSPECT ALODINE   07/06/14 30

| 8.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location:_____   07/06/14 30

| 9.0 | QC21 | FINAL INSPECTION/W/O RELEASE |

Comment: FINAL INSPECTION/W/O RELEASE   07/06/14 30

Job Completion

Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32353
Description: Strut		Part Number:	D2324-3
Inspection Dwg: D2324　　Rev: C			Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] **First Article**　　　[ ] **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+/-0.010	.259	✓			
Ø0.191	+/-0.010	.192	✓			
0.750	+/-0.010	.750	✓			
0.375	+/-0.010	.3755	✓			
1.875	+/-0.010	1.877	✓			
5.250	+/-0.010	5.250	✓			
5.625	+/-0.010	5.625	✓			

Measured by: SA	Audited by: En	Prototype Approval:	N/A
Date: 01.06.12	Date: 07.06.12	Date:	N/A

Rev	Date	Change		Revised by	Approved
A	04.06.10	New Issue	P/O D2324-1	KJ/JLM	
B	06.03.08	Dwg Rev changed		KJ/JLM	

DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2324	SHEET 1 OF 1
DATE		TITLE	SCALE
04.12.14		STRUT	

DART

A	94.11.08	NEW ISSUE
B	96.05.07	UPDATE MATERIALS
C	04.12.14	UPDATE NOTES

RELEASED

04.12.16

6.000(REF)

D2324-5

AN3-12A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(TWO PLACES)
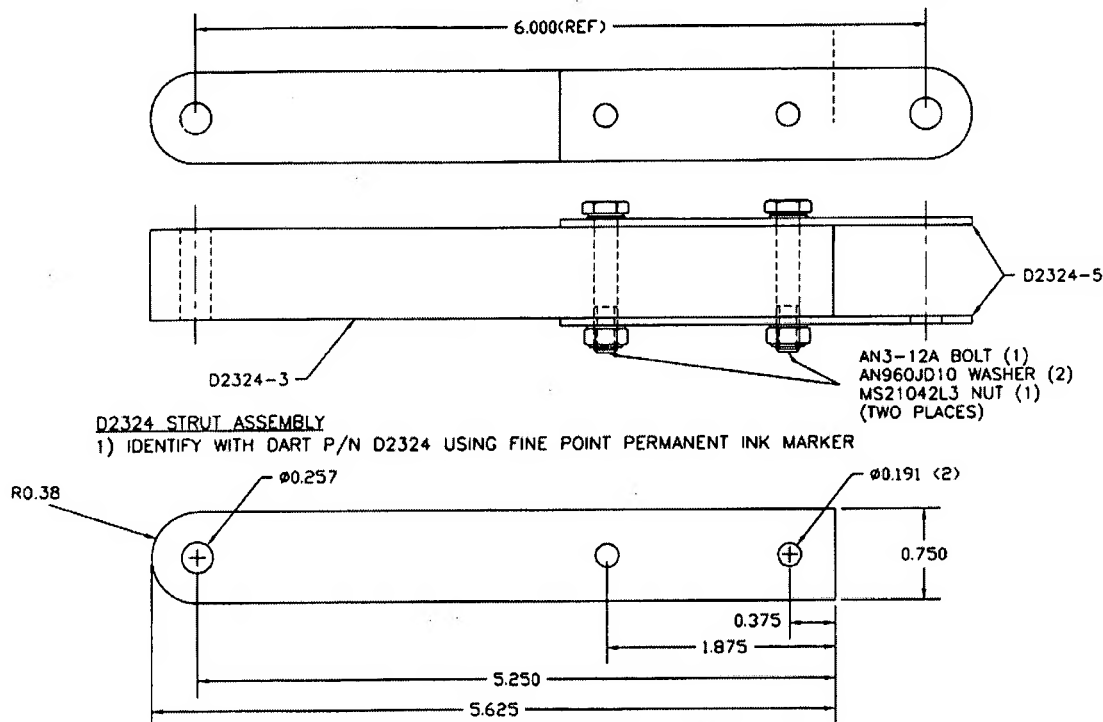
D2324-3

D2324 STRUT ASSEMBLY
1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER

R0.38   Ø0.257   Ø0.191 (2)
0.750
0.375
1.875
5.250
5.625

D2324-3
1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75
   (REF DART SPEC. M6061T6B0.750X00.750)
2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
             POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

R0.38   Ø0.257   Ø0.191 (2)
0.750
0.375
1.875
3.000
3.375
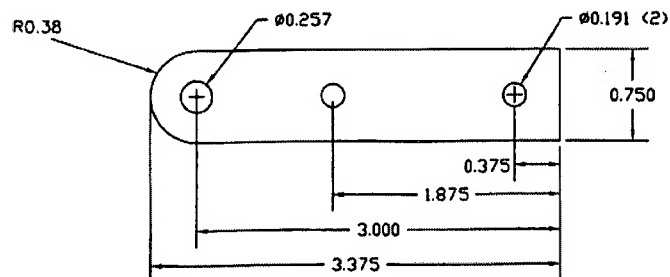
D2324-5
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)
             (REF DART SPEC. M304S16GA)
2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.005 TO 0.015
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED